

Date: Thursday, 7/20/2006 1:09:01 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 27997B					
Estimate Number	: 10193					
P.O. Number	: N/A			Part Number	: D2512	
This Issue	: 7/20/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2512 REV D2	
First Issue	: 7/20/2006		Type	: LARGE FAB ASSY		
Previous Run	: 27996B			Project Number	: N/A	
Written By	:			Drawing Revision	: D2	
Checked & Approved By	:			Material	: N/A	
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF			Due Date	: 8/19/2006	
	Est Rev:N 06.04.05 Added level21			Qty:	1	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s) M101359 → 91,89"	
		Pick: 3/4"x3/4" 304/316 SS tube .063" wall	CPL 06-07-26
		Batch: M101561 → 185,04" M101309 → 241,6"	
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	327327 CPL 06-07-25
3.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	326631-2 CPL 06-07-25
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick: Qty Part Number Description Batch	326742 CPL 06-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:09:02 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27997B

Part Number: D2512

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D22321	Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description
2 D2232-1	Hinge plate

Batch
B27521B

OPC 06-07-25

6.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description
2 D2581	Mounting Bracket

Batch
B27581

OPC 06-07-25

7.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number	Description
18 sf	M304EX0.75-16F Expanded Metal

Batch
M101707

OPC 06-07-27

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

OPC 06-07-31

9.0	QC9/6	DDIMENSIONAL & WELDING INSPECTION
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Comment: DDIMENSIONAL & WELDING INSPECTION

OPC 06-08-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: Date: 08/27

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 7/20/2006 1:09:02 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27997B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/08/16 ①

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M101667

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF. 06/08/24

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.P.

MF. 06/08/24

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

MF. 06/08/25

Job Completion



6/06.08.25
u de-08.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



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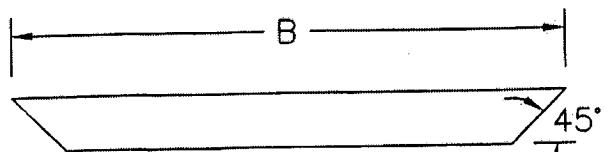
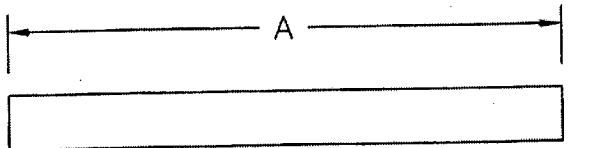
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE NTS

RELEASED
01.04.27 *CH*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	CH CP 03.01.20	ADD D2012-117 FOR D130-701-041
D2	CH CP 09.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

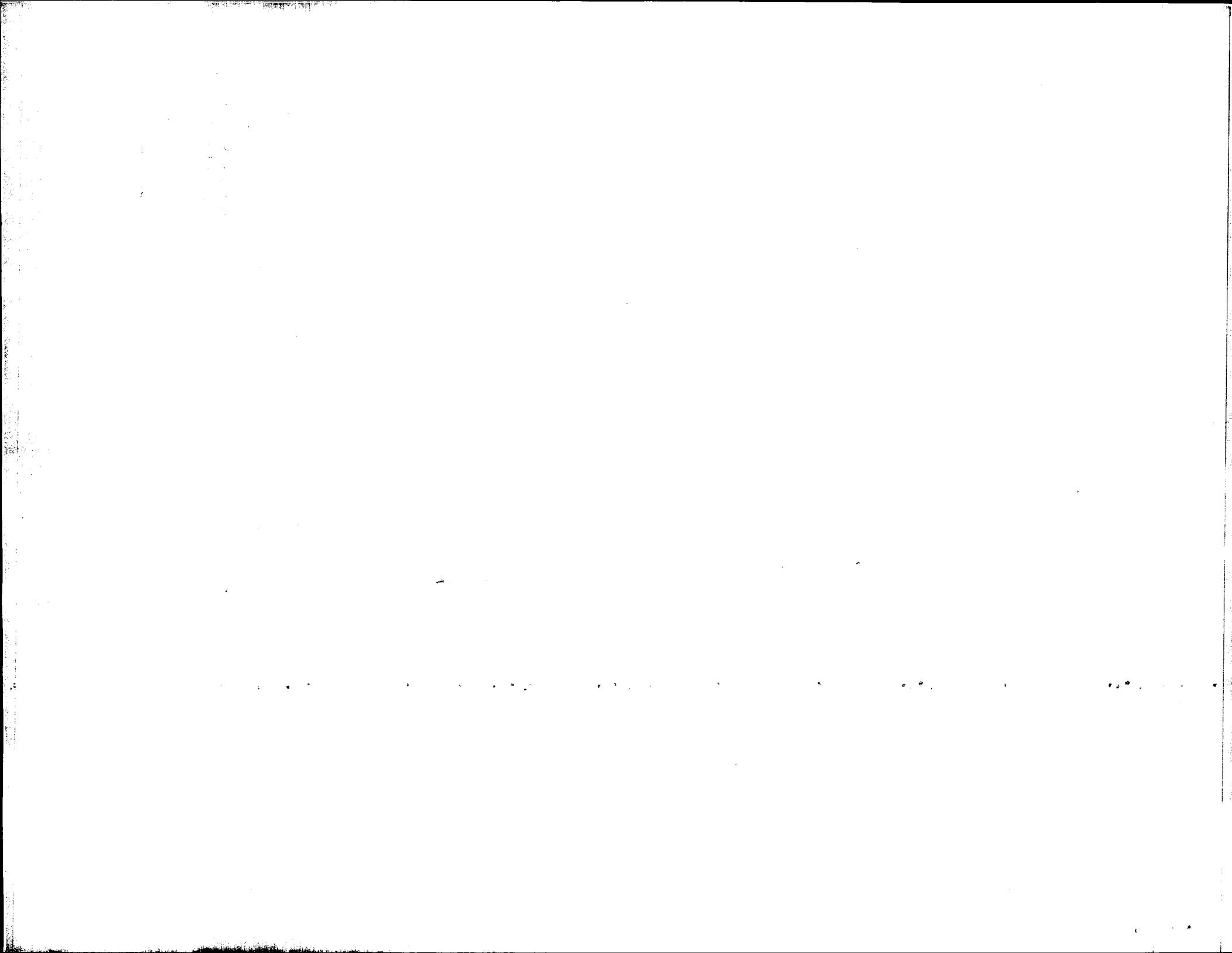


D2512-1/-3/-5/-7

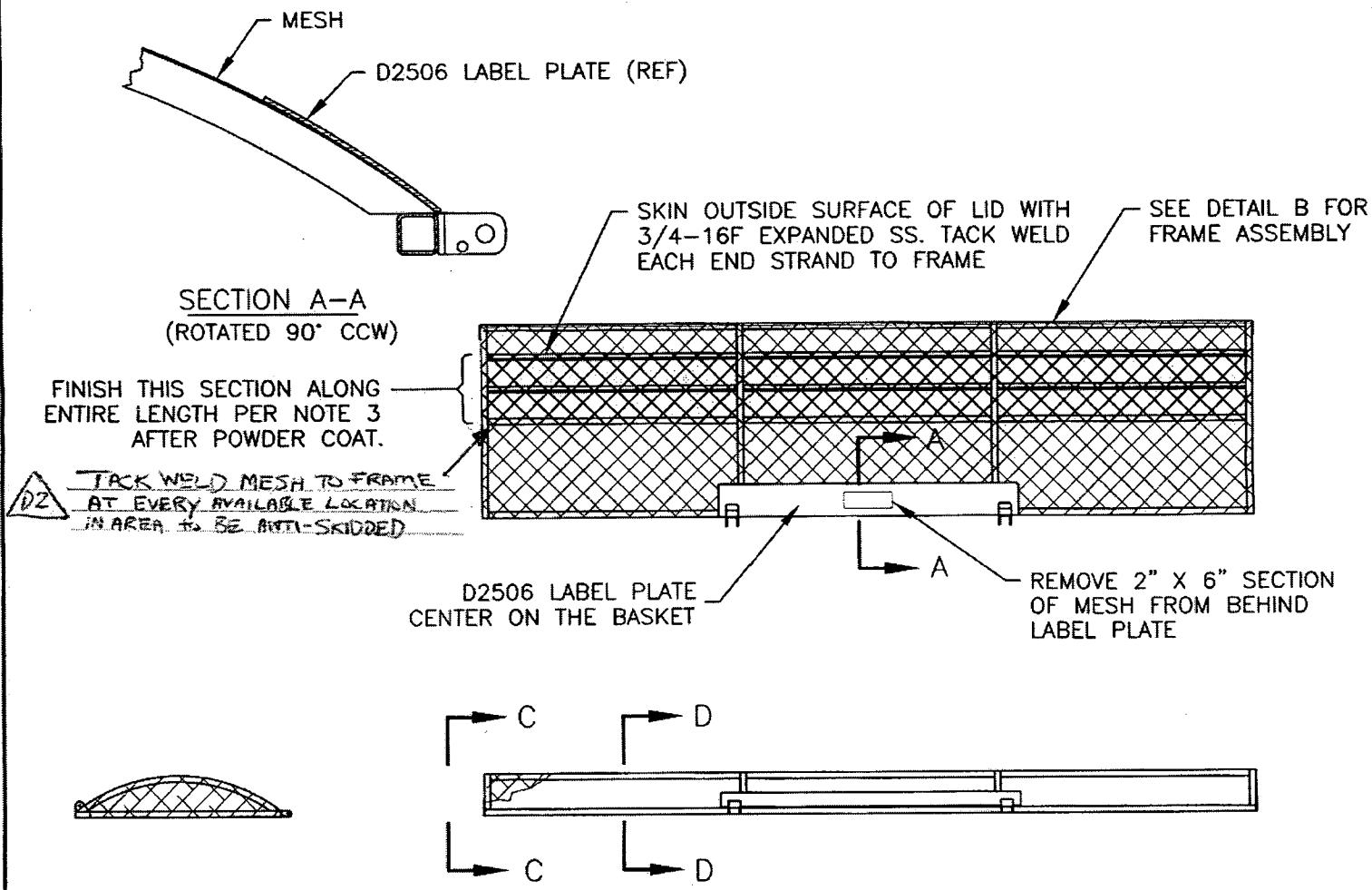
CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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D2512 BASKET LID ASSEMBLY

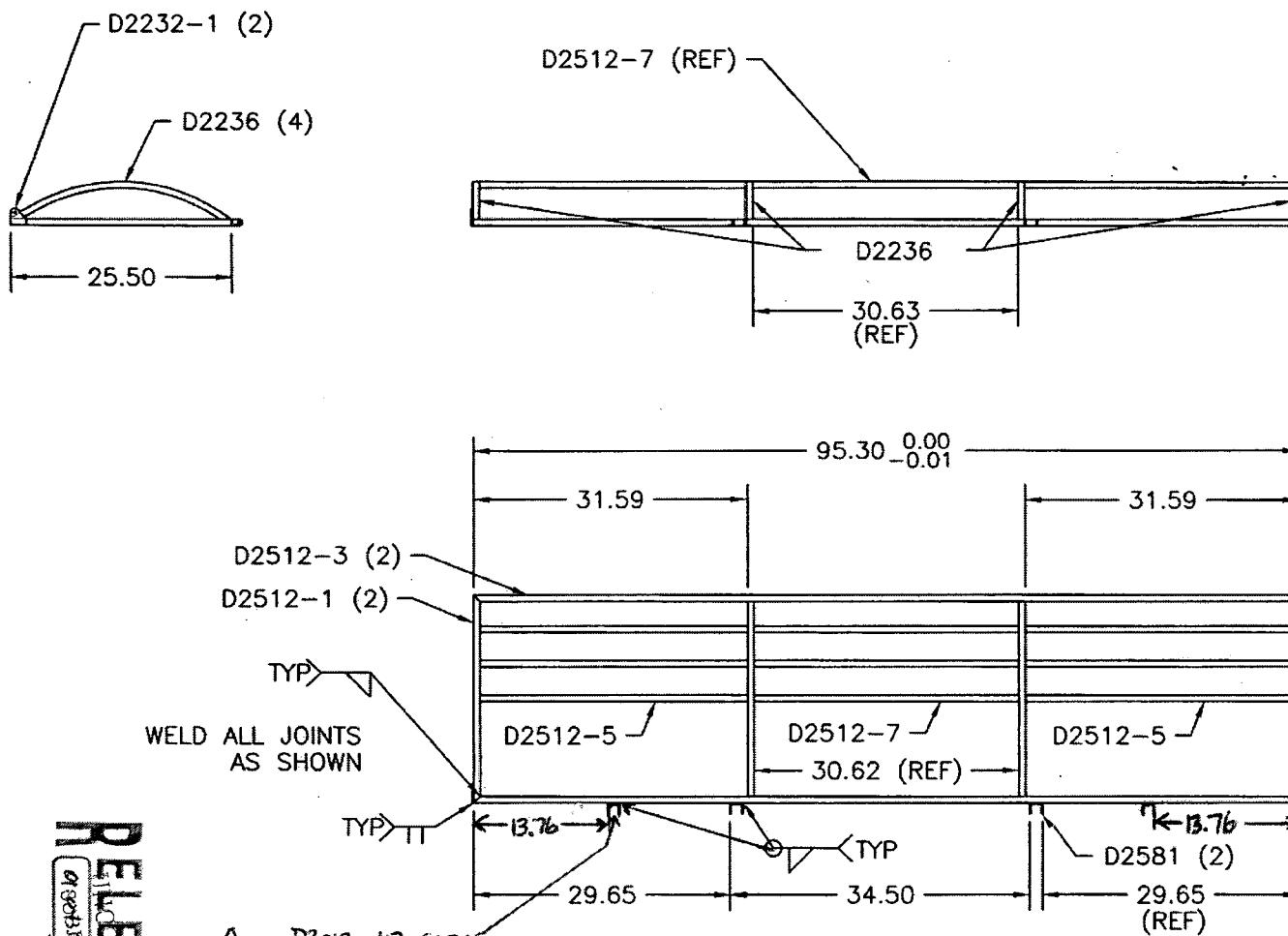
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART		DRAWN BY <i>JP</i>	DART AEROSPACE LTD		
DESIGN BW	CHECKED <i>✓</i>		APPROVED <i>✓</i>	DRAWING NO. D2512	HAWKESBURY, ONTARIO, CANADA
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)			REV. D SHEET 2 OF 4 SCALE 1:20	

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01/04/95

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	GP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2512
DATE		TITLE
01.04.19		BASKET LID ASSEMBLY (350/212)
		REV. D
		SHEET 3 OF 4
		SCALE



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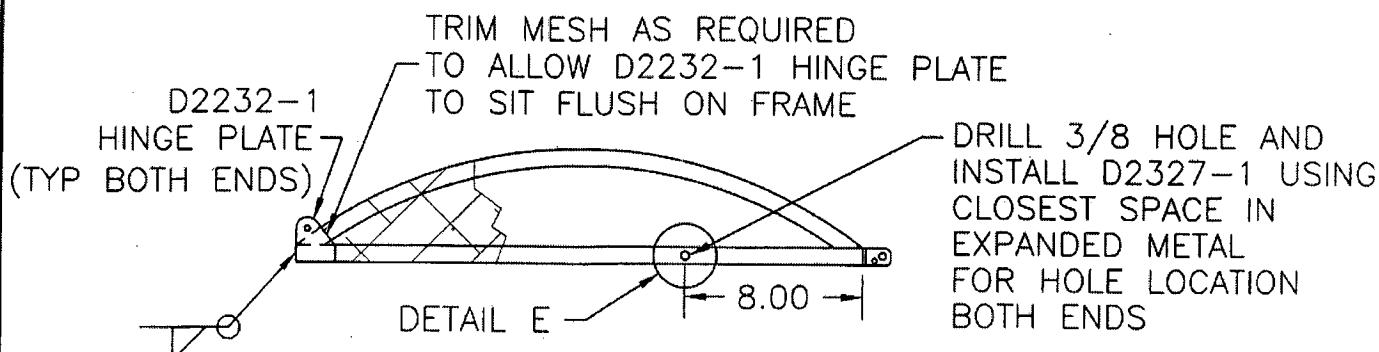
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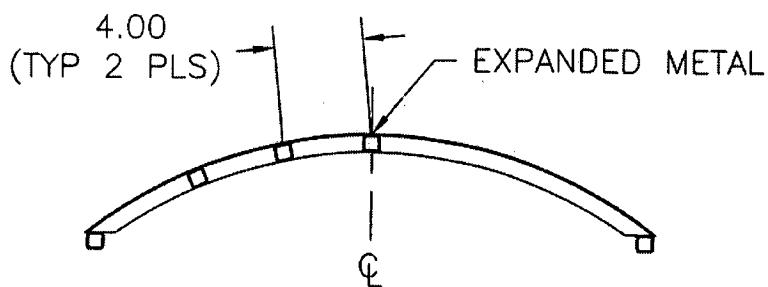
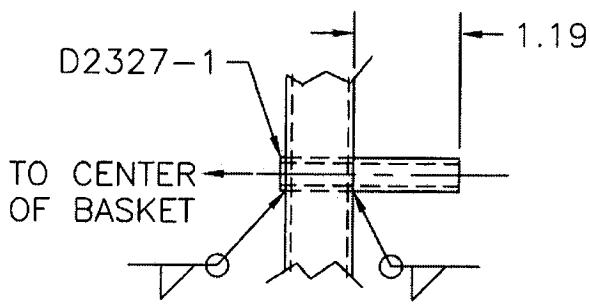
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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



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SECTION D-D SAME BOTH CENTER RIBS

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